

174 .750

Work Order ID 84947

May-29-12 1:13:23 PM

84947

Page 1

Item ID: D3407-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Stem

Start Date: 29/05/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/30

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3407	Rev E								

100 DOOSAN LATHE 0.00
100
 Doosan Memo 0.00 40 0
 Doosan Lathe 1-Turn as per Folio FA597 Rev: E & Dwg D3407 Rev: E 2-Deburr
SD 12/06/15

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00 40 0
 Quality Control SD 12/06/15

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00 40 0
 Quality Control SD 12/06/106

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84947***84947***

Page 2

May-29-12 1:13:23 PM

Item ID: D3407-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Stem

Start Date: 29/05/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
130									
Packaging	Memo	0.00				<u>40</u>		<u>5 uc 12/06/06</u>	
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/06/06MLJ 12/06/06

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-29-12 1:13:26 PM

Page 1

Work Order ID: 84947

84947

Parent Item: D3407-3

D3407-3

Parent Item Name: Stem

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP Rev:A05.10.18New issueKJ/EC

IPP Rev:B Now on Doosan 08-05-14 JLM Verified By:DD

IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M174R0.750

Purchased

No

100

f

57.2590

0.366

15.41053

M174R0 750

17-4 round bar .750

**

5/12/15

Location

Loc Qty

Loc Code

MAT030

57.259

117683

0.465

118483

0.359

120196

5

121196

3.435

121282

48

3.435 Pt
1221

4 Pt
4 Pt

W/O:		WORK ORDER CHANGES					
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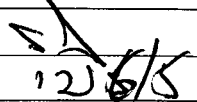
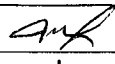
NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order:	84947
Description: Stem		Part Number:	D3407-3
Inspection Dwg: D3407	Rev: E	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.063	+/-0.010	0.063	/		5A-9	Uen
1/4-28 UNF	Max: 0.2668 Min: 0.2635	0.265	/			
Major Ø	Max: 0.249 Min: 0.2425	0.245	/			
Ø0.625	+/-0.010	0.625	/			
Ø0.363	+/-0.010	0.363	/			
Ø0.750	+/-0.010	0.749	/			
R0.100	+/-0.010	R.100	/			
0.470	+/-0.010	0.470	/			
0.250	+/-0.010	0.255	/			
2.555	+/-0.010	2.550	/			
3.305	+0.000/-0.010	3.298	/			
4.325	+/-0.010	4.325	/			
0.150	+/-0.010	0.153	/			
0.550	+/-0.010	0.553	/			
0.625	+/-0.010	0.622	/			
0.250	+0.010/-0.000	0.260	/			

Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 12/6/06	Date: 12/6/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.08	New Issue	KJ/JLM	
B	07.09.26	Tolerances revised	KJ/EC	
C	08.05.14	Dimensions updated per Dwg Rev D	KJ/JLM	
D	08.10.07	Dimensions updated per Dwg Rev E	KJ/DD 	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM

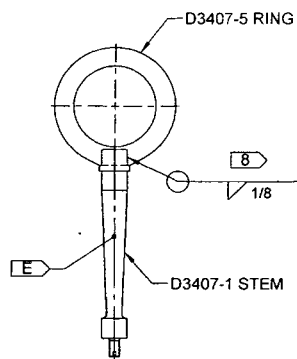
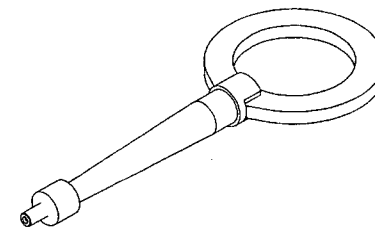
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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

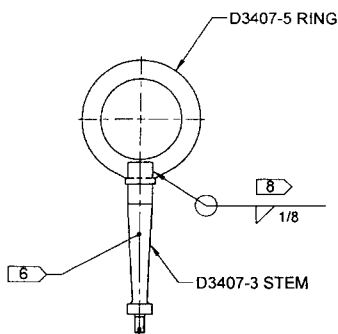
WORK ORDER

NO. 84947 MLJ

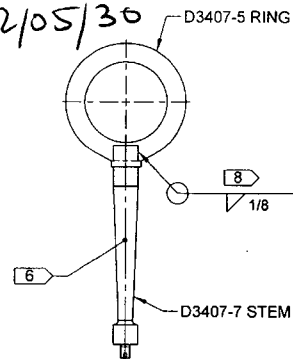
12/05/30



D3407-041 TOW RING



D3407-043 TOW RING



D3407-045 TOW RING

RELEASED

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/-3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/-3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/-3 LONGER FOR FIT WWASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN			
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
DATE	08.07.23	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PREPARED AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

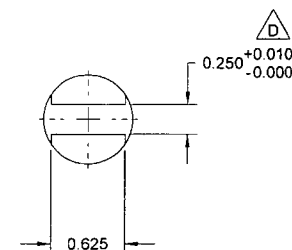
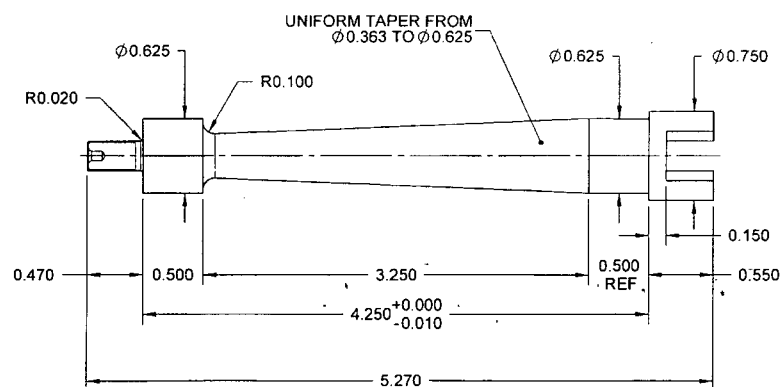
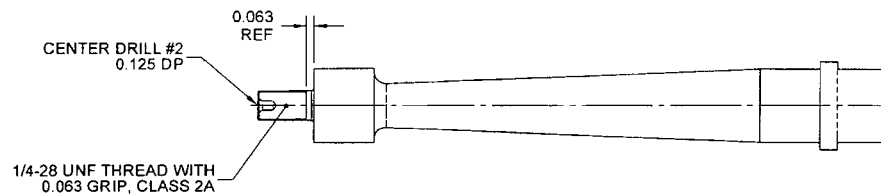
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3407-1 STEM

RELEASED

NOTES:

- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

DESIGN		DART AEROSPACE USA, INC.	
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MFG. APPR.		D3407	SHEET 2 OF 5
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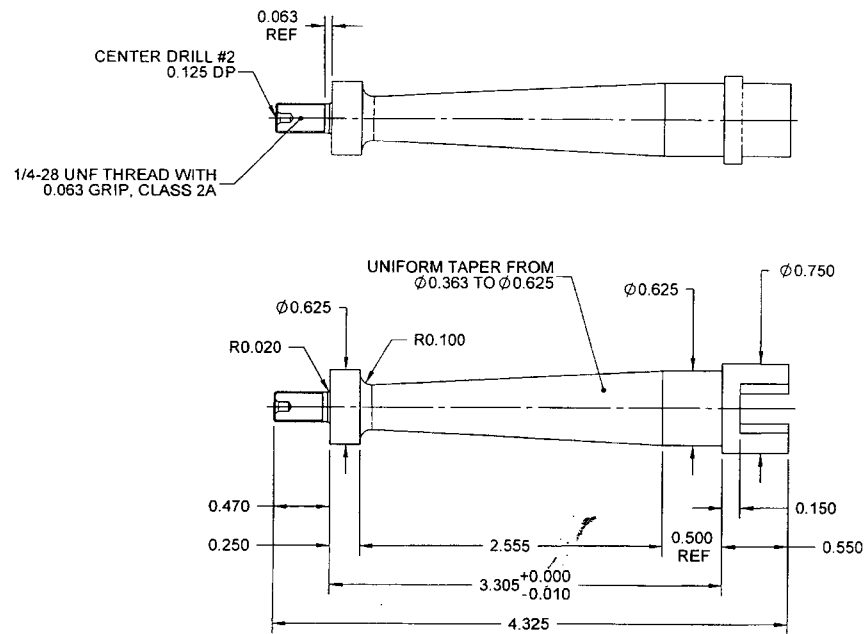
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



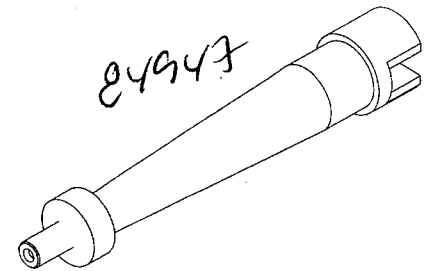
D3407-3 STEM

- NOTES:**
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

DESIGN		DART AEROSPACE USA, INC.
DRAWN		PORT HADLOCK, WA
CHECKED		DRAWING NO. D3407
MFG. APPR.		REV. E
APPROVED		SHEET 3 OF 5
DE APPR.		TITLE TOW RING
DATE	08.07.23	SCALE NTS

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08-08-01 11:48



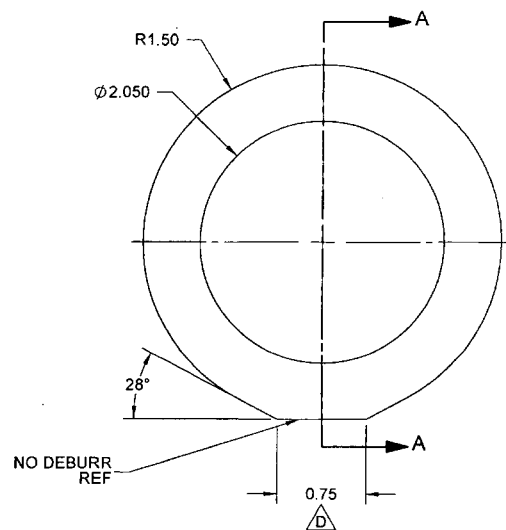
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

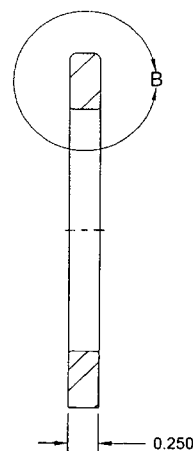
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

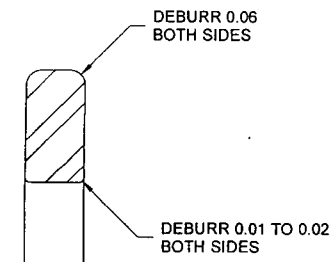
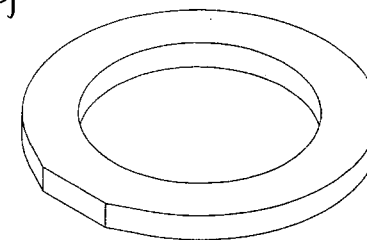
NOTE: Date & initial all entries



D3407-5 RING



SECTION A-A



**DETAIL B
SCALE 2X**

RELEASED
08-06-01/10

- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

DESIGN	92	DART AEROSPACE USA, INC.	
DRAWN	1/8	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 4 OF 5
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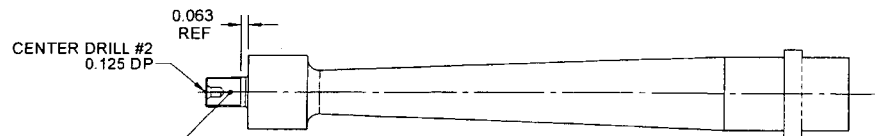
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

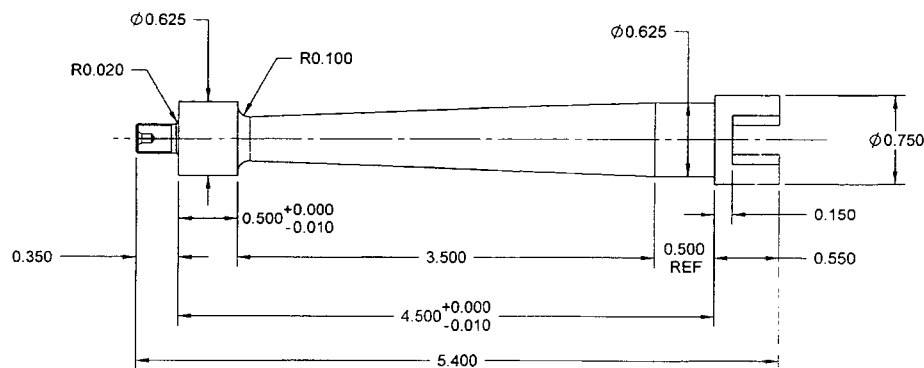
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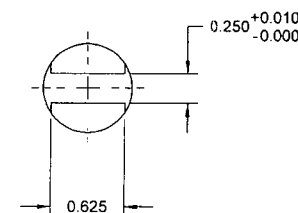
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1/4-28 UNF THREAD WITH
0.063 GRIP, CLASS 2A



D3407-7 STEM



DESIGN	AJS	DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 5 OF 5
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- NOTES:**
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 - 2) FINISH: NONE
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 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.34 lbs

RELEASED

W/O:		WORK ORDER CHANGES					
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